

Order ID 70492 LM



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Thursday, June 09, 2011 3:20:00 PM

Item ID: D206-642-151

Revision ID:

Item Name: Replacement Skidtube

Start Date: 6/9/2011 Start Qty: 1.00

Required Date: 6/20/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 11-06-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

N

0.00

100



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

Dart Aerospace Ltd

## WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 70492**

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Item ID: D206-642-151

Accept



Setup Start



Revision ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

**Memo**

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐

M1128660/M115778

BE 11/07/07

4-Grind weld flush to cap on top surface only.

BE 11/07/07

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

BE 11/08/26

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole &amp; 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 &amp; D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 &amp; doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

Dart Aerospace Ltd

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.  
\*\*\*\*no wearplate holes for this skidtube\*\*\*\*

17-Deburr tube and blow out chips from inside the tube

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

8/11/09/29

BE 11/08/20

Dart Aerospace Ltd

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	Ac 11-08-29			(X1)	0		
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				1	0		BE 11/09/08
160  Skidtubes Skidtubes	Skidtubes  Memo 1-Open holes to finished size as per Dwg D3804, (without cutting fluid) 2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid) 3-Deburr and blow out all chips from inside the tube	0.00  0.00				1	0		BE 11/09/08

Dart Aerospace Ltd

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

180

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

D2654-1

2-Bond ~~D2654-3~~ web in place as per QSI 015. Ensure holes lined up. Allow 12 Hrs. cure time before cutting

Start Date: 11/09/12 Time: 3:00

Finish Date: 11/09/13 Time: 7:00

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Sikaflex-291 ☐ 118393

Sikaflex expire date: ☐ 12/04/05

BE 11/09/12

P10 →

Dart Aerospace Ltd

W/O: 70492		WORK ORDER CHANGES					PERM CAG	
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
w/8/25	± 180	w/o Description call for the incorrect web. Fix to have correct web		ALREADY DONE HJ			S 11/08/25	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

8/11/13

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

0.00



Skidtubes

Skidtubes

**Memo**

0.00

1-remove alodine from around hole and prepare for welding

BE 6/09/14

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☒ M112860

BE 11/09/14

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☒ NONE

BE 6/09/14

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

DD

11-9-22

Dart Aerospace Ltd

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**Work Order ID 70492**

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Customer:

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

xl

DL

11/09/27

220

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.09.27

230

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

QC10  
8/10/27  
8/10/27

⑨

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

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240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BL 11-9-29

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:

1:00  
320°F  
1:30

0.00

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1X Ø M-L 11/04/29

1 d M 11/06/08

M118439

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

Batch: M118313

**Dart Aerospace Ltd**

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



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290  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	S w/10/06/11						
300  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	S w/10/06/11			 LM			
310  Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D206-642-151 Location: <u>74399/PP</u> PPP Rev: _____	0.00 0.00							

**Dart Aerospace Ltd**

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Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/2011  
CMF  
11-10-19

**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, June 09, 2011 3:20:07 PM

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Work Order ID: 70492

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube




Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV:N DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620  Skidtube, 206 Skidtube		Manufactured	No				Each	12.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG	371016	12							
					62684	1							
					68135	1							
					68136	10							
D3286-1  Doubler		Manufactured	No				Each	36.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002		36							
					52844	15							
					64563	21							
D2647  Cap		Manufactured	No				Each	30.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002		30							
					55352	30							

u/07/07

BE 11/08/05

BE 11/07/07

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Thursday, June 09, 2011 3:20:07 PM

Work Order ID: 70492

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased No

Each

678.0000

52



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

678

115698

39

116471

139

117816

500

D2654-1

Manufactured No

Each

0.0000

1



Web

D2649

Manufactured No

Each

207.0000

19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

195

68224

40

70394

155

LG001

12

65317

1

68507

11

D3286-3

Manufactured No

Each

31.0000

2



Spacer

Location

Loc Qty

Loc Code

LG002

31

46643

1

64564

30

2

BE 11/09/12

M118686 x70

BE 11/09/12

B 64562 x1

BE 11/09/14

B 73390 x19

BE 11/09/14

**Dart Aerospace Ltd**

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Page 3

Thursday, June 09, 2011 3:20:07 PM

Work Order ID: 70492



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

Each

579.0000

2



Cherry Rivet

DL  
11/09/27

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

577

117086

77

117849

500

2

CR3212-4-03

Purchased

No

Each

1,226.000

2



Cherry Rivet

DL  
11/09/27

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1224

114859

1224

2

D2680-041

Manufactured

No

Each

35.0000

1



Nut Plate

DL  
11/09/27

Location

Loc Qty

Loc Code

ST020

35

55366

17

70088

18

1

D3805-041

Manufactured

No

Each

2.0000



Wearplate Assembly Fwd, Low Gear

\*

DL  
11/09/27

Location

Loc Qty

Loc Code

FP

2

64565

2

B73813

21

Thursday, June 09, 2011 3:20:07 PM

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Page 3

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 09, 2011 3:20:07 PM

Page 4

Work Order ID: 70492

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3805-045

Manufactured No

Each 2.0000

1



Wearplate Assembly Aft, Low Gear

\*



11/10/04

Location

Loc Qty

Loc Code

FP

2

1373721

X1

64566

2

Each

255.0000

AN3-37A

Purchased No



Bolt



11/10/04

Location

Loc Qty

Loc Code

ST353

205

105425

69

111668

136

X7

ST354

50

117619

50

Each

0.0000

AN960JD10

NAS1149D0363J

Purchased No



Washer

\*

1118097



11/10/04

MS21042L3

Purchased No



Nut

Each

2,322.000



11/10/04

Location

Loc Qty

Loc Code

ST300

2322

116391

9

116549

613

117441

800

117601

400

117885

500

1118451

X7

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Page 4

**Dart Aerospace Ltd**

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Page 5

Thursday, June 09, 2011 3:20:08 PM

Work Order ID: 70492

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3873-1 Manufactured No

Each 112.0000

14



yl 11/10/04

Bushing

Location

Loc Qty

Loc Code

ST084

100

1371837

x14

68247

100

ST088

12

64760

12

AN960JD416 NAS1149D0463J Purchased No

Each 0.0000

1



1118384



(x1) yl 11/10/04

Washer

D2651-1 Manufactured No

Each 248.0000

6



yl 11/10/04

Plug

Location

Loc Qty

Loc Code

fpa

121

69018

121

FP-A

127

57869

7

66445

10

67263

12

67760

98

x6

D2651-3 Manufactured No

Each 576.0000

6



yl 11/10/04

O-Ring

Location

Loc Qty

Loc Code

FP-A

576

61962

132

66956

444

y6

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Page 5

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Page 6

Thursday, June 09, 2011 3:20:08 PM

Work Order ID: 70492

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06 Purchased No

Each 61.0000



1  
JL 11/10/04

Screw

## Location

## Loc Qty

## Loc Code

FP-A

26

115460

26

✓1

ST292

35

115460

35

D2646 Manufactured No

Each 24.0000



1  
JL 11/10/04

Aft Cap

## Location

## Loc Qty

## Loc Code

FP006

23

62678

23

B71070

✓1

FP-4

1

69019

1

MS27039-1-08 Purchased No

Each 768.0000



2  
JL 11/10/04

Screw

## Location

## Loc Qty

## Loc Code

ST291

768

115108

468

1118378

✓2

117423

300

AN960JD10L NAS1149D0332J Purchased No

Each 0.0000



2  
(x2) JL 11/10/04

Washer

1117087

Thursday, June 09, 2011 3:20:08 PM

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Page 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

#### NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 10492

11-06-9

RELEASED  
UP 09.03.03  
per ECR 09-530

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>q</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>q</i>	DRAWING NO. REV. A	
CHECKED	<i>q</i>	D3804 SHEET 1 OF 5	
MFG. APPR.	<i>q</i>	TITLE SCALE	
APPROVED	<i>q</i>	SKIDTUBE ASSEMBLY, 206A/B NTS	
DE APPR.	<i>q</i>	DATE 08.07.07	
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Dart Aerospace Ltd

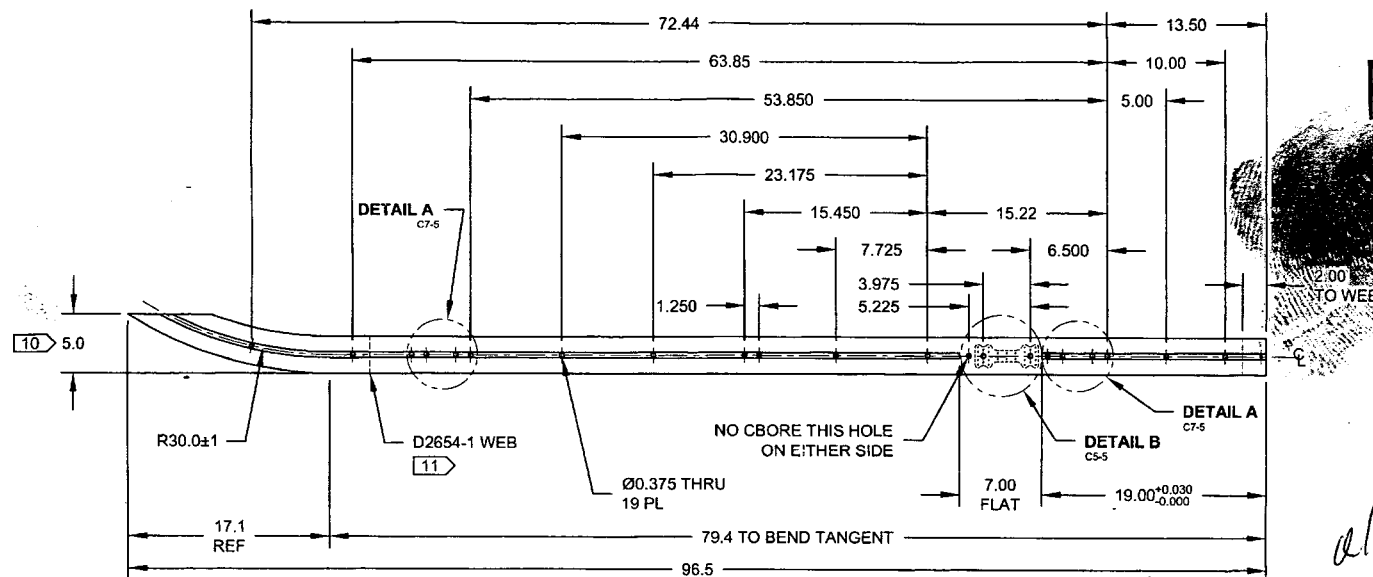
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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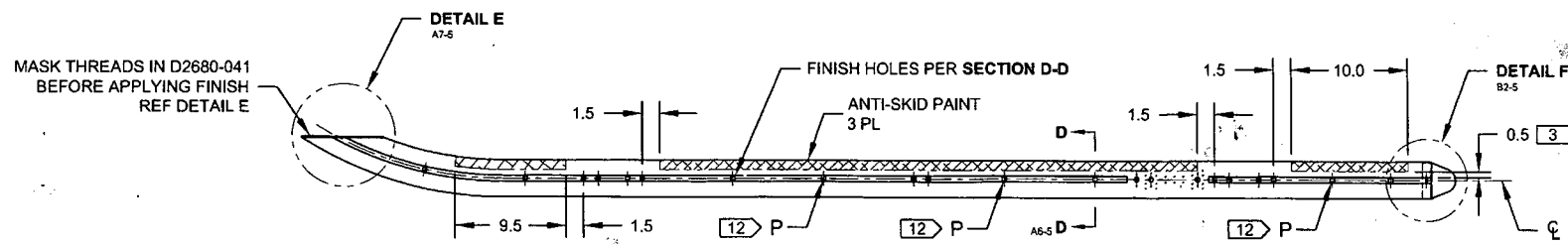
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED  
09.03.03



**D3804-041 BENDING/DRILLING DETAIL**



**D3804-041 ASSEMBLY/FINISHING DETAIL**

DESIGN	91	<b>DART AEROSPACE USA, INC</b>	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 2 OF 5
APPROVED	91	TITLE	SCALE
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
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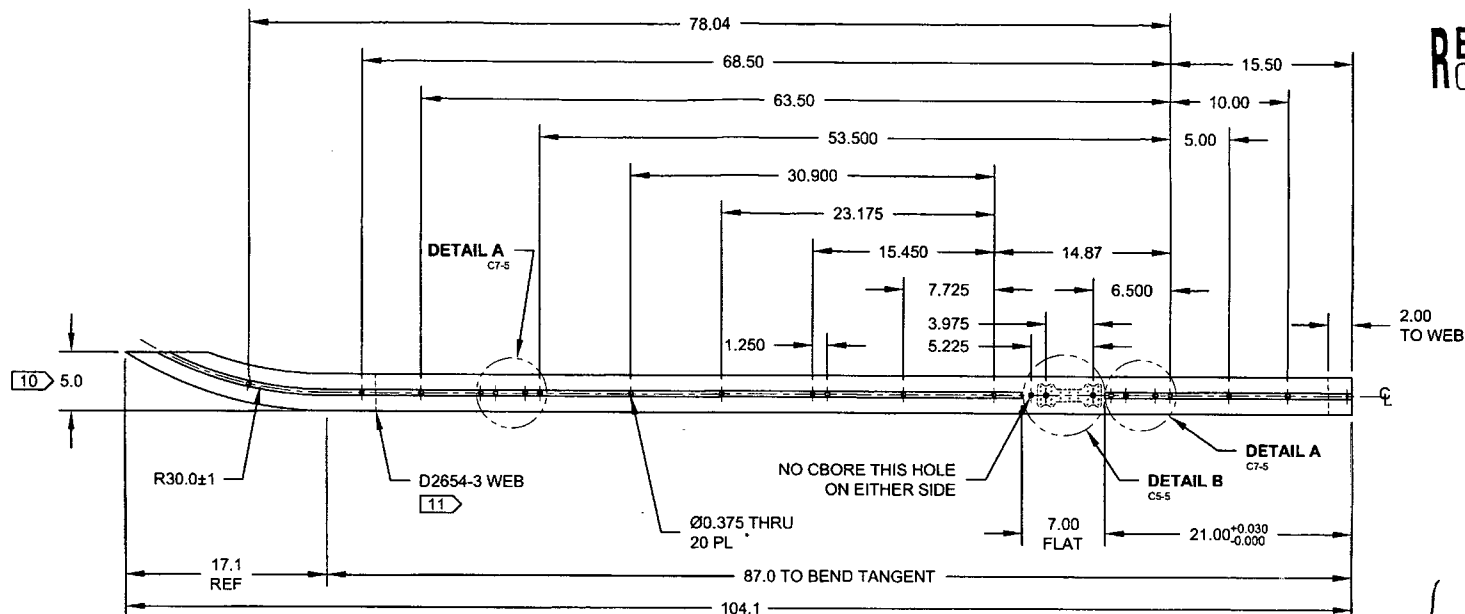
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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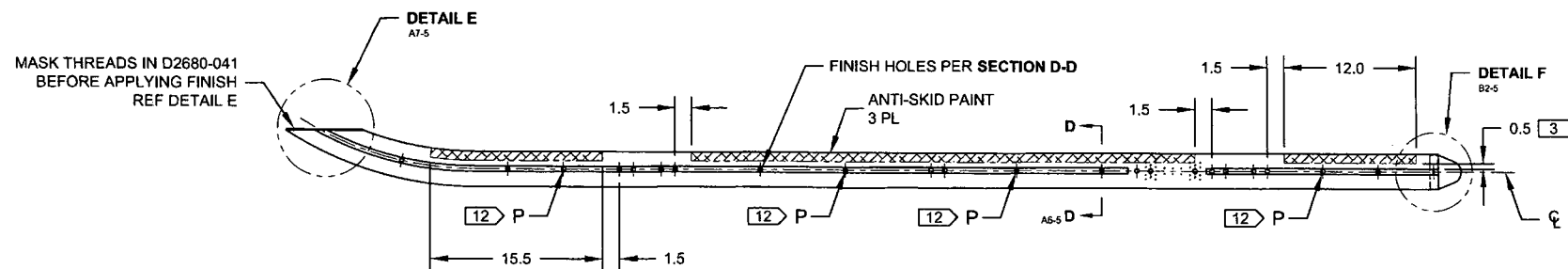
**NOTE:** Date & initial all entries



RELEASED  
09.03.03



**D3804-043 BENDING/DRILLING DETAIL**



**D3804-043 ASSEMBLY/FINISHING DETAIL**

DESIGN	97	<b>DART AEROSPACE USA, INC</b>	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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**Dart Aerospace Ltd**

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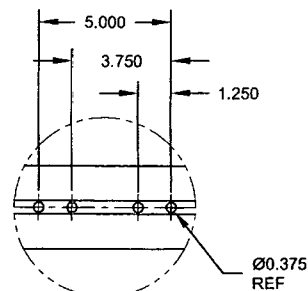
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

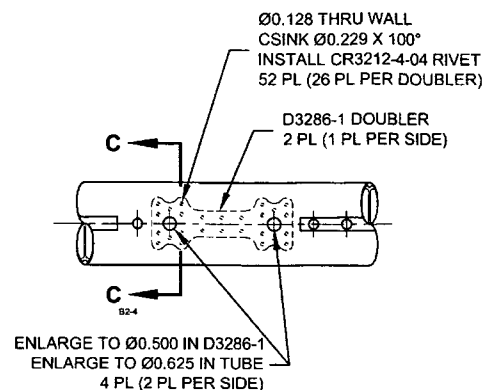
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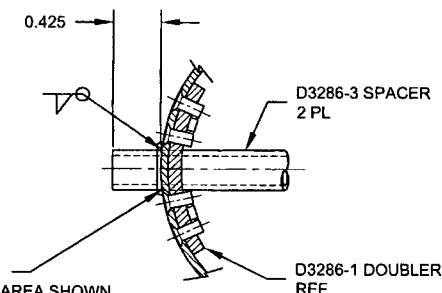
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UP 09.05.07



**DETAIL A** D6-2  
C2-2  
D6-3  
C2-3  
SCALE NONE

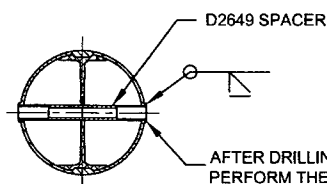


**DETAIL B** C3-2  
C3-3  
SCALE NONE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO 0.500
  4. ENLARGE HOLES IN TUBE TO 0.625 AND CHAMFER HOLE 0.03 X 45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE AND GRIND FLUSH

**SECTION C-C** C6-4  
PARTIAL SECTION  
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR 0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. CBORE TO 0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

**SECTION D-D** A4-2  
A4-3  
FOR 0.375 HOLES ONLY  
SCALE NONE

DESIGN	97	<b>DART AEROSPACE USA, INC</b>	
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w/078492

**Dart Aerospace Ltd**

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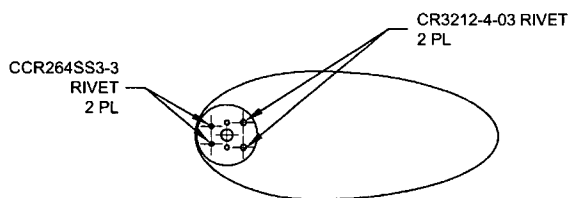
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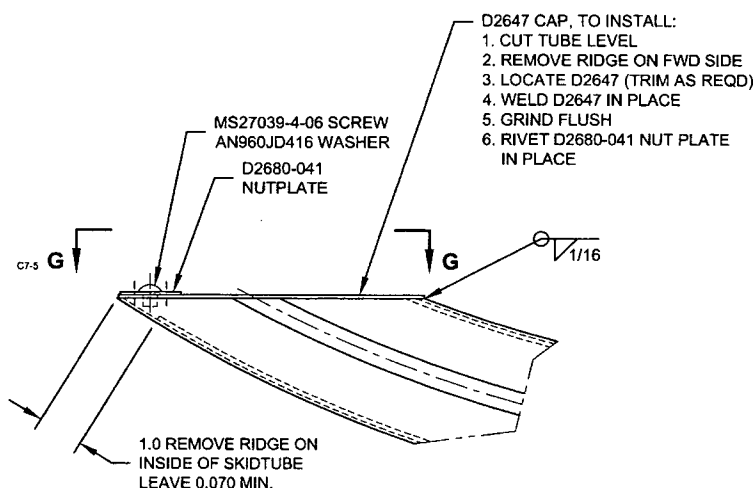
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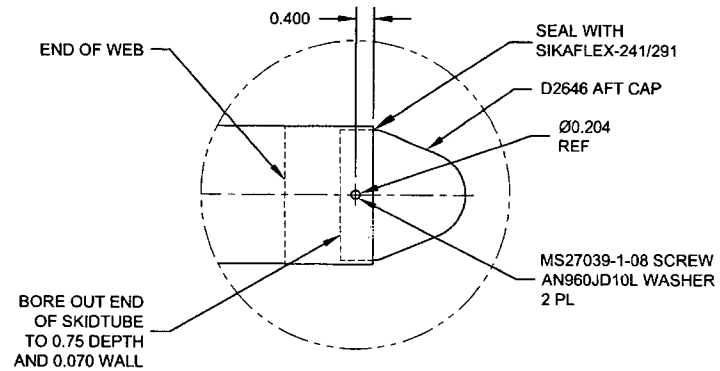
RELEASED  
09 03 03



**VIEW G-G**  
SCALE NONE A7-5



**DETAIL E**  
SCALE NONE B7-2  
B7-3



**DETAIL F**  
SCALE NONE B2-2  
B2-3

W/ 70492

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Dart Aerospace Ltd

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NOTE: Date & initial all entries

NO. 266

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 704089  
Part number: 5206 642 151  
Description: 206  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier fat davis Date of Test Coupon 11-09-22

Welder Barclay Elliott Date of Test Coupon 11-09-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld